

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011720**Date Inspected:** 27-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (6CE)

This QA inspector witnessed final tension verification for floor beam to side panel clips (North & South) of Segment 6CE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP44, 45, 46 & 47: M16 X 45 – DHGM 160001 – 210 NM

PP44, 45, 46 & 47: M16 X 65 – DHGM 160006 – 180 NM

PP44, 45, 46: M16 X 50 – DHGM 160004 – 180 NM

OBG # TRIAL ASSEMBLY YARD (6CE)

This QA inspector witnessed final tension verification for floor beam to bottom panel clips (North & South) of Segment 6CE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP44, 45, 46 & 47: M16 X 45 – DHGM 160001 – 210 NM

PP44, 45, 46 & 47: M16 X 65 – DHGM 160006 – 180 NM

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OBG # TRIAL ASSEMBLY YARD (6AE)

This QA inspector witnessed final tension verification for lower chevron and upper chevron of Segment 6AE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP 37 (S), PP 38 (N): M22 X 70 – DHGM 220004 – 453 NM
M22 X 80 – DHGM 220050 – 486 NM
PP 37 (S) East, PP 38 (N) East: M22 X 75 – DHGM 220005 – 473 NM

OBG # TRIAL ASSEMBLY YARD (6AW)

This QA inspector witnessed final tension verification for T-Stiffener splice (Side panel at cross beam side) of Segment 6AW. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP38-PP40: M22 X 65 – DHGM 220021 – 543 NM

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (7BE-7CE)

FCAW Process:

Welding of weld joint –007 located on PCMK OBE7C, Side panel transverse splice joining 7BE and 7CE. Welder is identified as 068596. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

OBG # TRIAL ASSEMBLY YARD (6CW)

FCAW Process:

Welding of weld joint –013 located on PCMK SEG031F, longitudinal diaphragm web to floor beam weld. Welder is identified as 068091. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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